

<b>Title</b>	<b>Feed and tail out a planer, and monitor planer performance</b>		
<b>Level</b>	<b>3</b>	<b>Credits</b>	<b>5</b>

<b>Purpose</b>	People credited with this unit standard are able to: manage safety and hazards when feeding and tailing out a planer; demonstrate knowledge of the operation and operating principles of a planer; feed timber into a planer; out-feed planed timber; monitor and record planer performance; and record downtime, and report machinery breakages.
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<b>Classification</b>	Solid Wood Manufacturing > Timber Machining
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<b>Available grade</b>	Achieved
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### Guidance Information

- 1 Legislation  
Health and Safety at Work Act 2015.  
Resource Management Act 1991.
- 2 Definitions  
*Accepted industry practice* refers to approved codes of practice and standardised procedures accepted by the wider wood manufacturing industry as examples of best practice.  
*Corrective action* refers to actions such as communication to management, communication to on-site technical person, communication to off-site technical support person, cleaning, communication with maintenance staff, recalibration, or changes made to the operating system in accordance with workplace procedures.  
*Workplace procedures* refer to documented policies and procedures set by the organisation carrying out the work, and to documented or other directions provided to staff, and applicable to the tasks being carried out. They may include but are not limited to – standard operating procedures, site specific procedures, site safety procedures, equipment operating procedures, quality assurance procedures, product quality specifications, references, approved codes of practice, housekeeping standards, environmental considerations, on-site briefings, supervisor’s instructions, and procedures to comply with legislative and local body requirements relevant to the wood manufacturing sector.
- 3 Assessment information
  - a All activities and evidence must meet workplace procedures and accepted industry practice.
  - b This unit standard includes the feeding of sawn or planed timber (feedstock) into a planing machine, and the out-feeding of planed timber.
- 4 Recommended unit standards for entry: Unit 164, *Tally timber*; Unit 165, *Handle, sort and stack timber*; and Unit 15774, *Demonstrate knowledge of timber machining*.

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## Outcomes and performance criteria

### Outcome 1

Manage safety and hazards when feeding and tailing out a planer.

#### Performance criteria

1.1 Hazards associated with feeding and tailing out a planer are identified and actions to be taken to manage the hazards are described.

Range hazards may include but are not limited to – moving equipment, lifting, noise; evidence of three is required.

1.2 Safe working practices associated with feeding and tailing out a planer are identified and applied.

Range practices may include but are not limited to – isolation procedures, lock-outs, emergency stops, machine guarding, wearing of appropriate safety equipment.

### Outcome 2

Demonstrate knowledge of the operation and operating principles of a planer.

#### Performance criteria

2.1 Purpose and function of the planer are explained.

2.2 Operating parameters and capability of the planer are explained.

Range may include but is not limited to – maximum and minimum cross sections, maximum and minimum output lengths.

2.3 Operating components of the planer are explained.

Range may include but is not limited to – feed system, fences, pressures, chip breakers, extraction system, electrical controls, cutterheads and cutters.

2.4 Roles and responsibilities of the planer operator are described.

### Outcome 3

Feed timber into a planer.

#### Performance criteria

3.1 Alignment of in-feed components is set.

- 3.2 Starting procedure for cutterheads and feed gear is carried out.
- 3.3 Input timber is checked for dimension, grade, and moisture content.
- 3.4 Foreign matter that could affect the cutters is removed.
- 3.5 Feedstock is fed so that the pressures hold it to the fence and bed.
- 3.6 Feedstock is fed butted together.
- 3.7 Bowed, cupped, and crooked stock is fed with the hollow aligned to the bed or fence.

#### **Outcome 4**

Out-feed planed timber.

#### **Performance criteria**

- 4.1 Alignment of out-feed components is set.
- 4.2 Dimension and finish of output timber are checked and reported including brand marks where required.
- 4.3 Output timber is sorted to customer requirements, and out-of-specification timber is segregated.
- 4.4 Timber is stacked and packed.
- 4.5 Problems associated with incorrect stacking are identified and corrected.

#### **Outcome 5**

Monitor and record planer performance.

#### **Performance criteria**

- 5.1 Operating faults and malfunctions are detected, and corrective action taken.  

Range	operating faults and malfunctions – mechanical, electrical, pneumatic, hydraulic.
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- 5.2 In-feed rate is maintained to meet the capability of the machine and production requirements.
- 5.3 Product quality is monitored, and any adjustments required are made.
- 5.4 Housekeeping standards are maintained.
- 5.5 Output data are recorded, and production identifications and records are maintained.

**Outcome 6**

Record downtime, and report machinery breakages.

**Performance criteria**

- 6.1 Downtime data are recorded.
- 6.2 Any machinery breakages are reported and recorded.

<b>Planned review date</b>	31 December 2024
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**Status information and last date for assessment for superseded versions**

Process	Version	Date	Last Date for Assessment
Registration	1	27 January 1994	31 December 2012
Review	2	24 October 1996	31 December 2012
Review	3	10 February 1999	31 December 2012
Review	4	18 December 2006	31 December 2012
Review	5	15 April 2011	N/A
Review	6	25 June 2020	N/A

<b>Consent and Moderation Requirements (CMR) reference</b>	0013
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This CMR can be accessed at <http://www.nzqa.govt.nz/framework/search/index.do>.

**Comments on this unit standard**

Please contact Competenz [qualifications@competenz.org.nz](mailto:qualifications@competenz.org.nz) if you wish to suggest changes to the content of this unit standard.